

Work Order ID 143880

March 24, 2016 4:14:19 PM

143880

Page 1

Item ID: D205-706-013 ~~12~~ Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fuel Purge Canister
 Start Date: 4/1/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 4/8/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: SL Date: 20160324 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D412-706	B								
100	Document Control	0.00	DAS 6 9-89			DAS 27 9-89			
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D205-706-013 CHG003								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

APR 15 2016

APR 15 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD205-706-013 Location : FG018								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

ship

MF

16-4-15

MC5

APR 15 2016

MF
16-4-15

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

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Work Order ID: 143880

143880

Parent Item: D205-706-013

D205-706-013

Parent Item Name: Fuel Purge Canister

Start Date: 4/1/2016

Required Date: 4/8/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:E 04.12.03 Remove AN6289-6D; Change Qty of AN924-6D
KJ/JLM IPP Rev:F 10.05.10 as per
chg002 DD verified :EC IPP Rev:G 12.12.07 as per IIN revB
DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2001-4 *D2001-4* Valve Assembly 1/4 inch		Manufactured	No			110	Each	7.0000	1	12			DAS 6 9-89

DAS
27
9-89

Location	Loc Qty	Loc Code
ST001	3	
134329	3	
ST012a	4	
142185	4	

D3262-041
D3262-041
Canister Assembly

DAS
27
9-89

Location	Loc Qty	Loc Code
ST492	1	
137616	1	

D3264-1
D3264-1
Bracket

DAS
27
9-89

Location	Loc Qty	Loc Code
ST209	6	
115581	2	
140748	4	

D3297-1-0121
D3297-1-0121
Hose Assembly

DAS
27
9-89

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Work Order ID: 143880

143880

Parent Item: D205-706-013

D205-706-013

Parent Item Name: Fuel Purge Canister

Start Date: 4/1/2016

Required Date: 4/8/2016

Start Qty: 1.00

Required Qty: 1.00

D3297-1-0130

Manufactured No

110 Each

5.0000

1

D3297-1-0130

Hose Ass'y

**

DAS
6
9-89

Location

Loc Qty

Loc Code

ST209

5

137517

2

142183

3

D3297-3-03503-89

Manufactured No

110 Each

4.0000

1

D3297-3-0350

Hose Assembly

**

DAS
6
9-89

Location

Loc Qty

Loc Code

ST209

4

134299

1

142184

3

D3298-001

Manufactured No

110 Each

2.0000

1

D3298-001

Tube Assembly

**

DAS
6
9-89

Location

Loc Qty

Loc Code

ST210

2

120131

1

141408

1

D3298-009

Manufactured No

110 Each

3.0000

1

D3298-009

Tube Assembly

**

DAS
6
9-89

Location

Loc Qty

Loc Code

ST210

3

120492

1

141614

2

DAS
27
9-89

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Work Order ID: 143880

143880

Parent Item: D205-706-013

D205-706-013

Parent Item Name: Fuel Purge Canister

Start Date: 4/1/2016

Required Date: 4/8/2016

Start Qty: 1.00

Required Qty: 1.00

D3299-1

Manufactured No

110 Each

4.0000

1 2 2
**

DAS
6
9-89

D3299-1

Fitting

BAS
27
9-89

Location

Loc Qty

Loc Code

ST030

4

103865

4

D3299-3

Manufactured No

110 Each

10.0000

1 1
**

DAS
6
9-89

D3299-3

Fitting

BAS
27
9-89

Location

Loc Qty

Loc Code

ST030

10

103866

10

D3301-1

Manufactured No

110 Each

5.0000

1 2 2
144161
**

DAS
6
9-89

D3301-1

Placard

BAS
27
9-89

Location

Loc Qty

Loc Code

ST030

5

132829

5

D3301-3

Manufactured No

110 Each

4.0000

1 2 2
144162 X1
**

DAS
6
9-89

D3301-3

Placard

BAS
27
9-89

Location

Loc Qty

Loc Code

ST030

4

137528

4

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Work Order ID: 143880

143880

Parent Item: D205-706-013

D205-706-013

Parent Item Name: Fuel Purge Canister

Start Date: 4/1/2016

Required Date: 4/8/2016

Start Qty: 1.00

Required Qty: 1.00

D3302-1
D3302-1
Doubler

Manufactured No 110 Each 13.0000 1 1.2

**

DAS
27
9-89

Location	Loc Qty	Loc Code
ST494	13	
125877	1	
137783	12	

DAS
6
9-89

D3302-3
D3302-3
Doubler

Manufactured No 110 Each 12.0000 1 1.2

**

DAS
27
9-89

Location	Loc Qty	Loc Code
ST494	12	
140808	12	

DAS
6
9-89

AN3-5A
AN3-5A
Bolt

Purchased No 110 Each 404.0000 4 4.8

**

Location	Loc Qty	Loc Code
FP001	34	
m133686	2	
m134055	32	
GA	4	
m133686	4	
ST350	366	
m134055	66	
m134502	300	

DAS
6
9-89

DAS
27
9-89

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Work Order ID: 143880

143880

Parent Item: D205-706-013

D205-706-013

Parent Item Name: Fuel Purge Canister

Start Date: 4/1/2016

Required Date: 4/8/2016

Start Qty: 1.00

Required Qty: 1.00

AN814-6D Purchased No 110 Each 6.0000

AN814-6D

Plug

DAS
27
9-89

Location Loc Qty Loc Code

ST326 6
m132677 2
m134405 4

**

DAS
6
9-89

AN815-6D Purchased No 110 Each 21.0000

AN815-6D

Union-M-Flare

DAS
27
9-89

Location Loc Qty Loc Code

ST326 21
m132680 21

**

DAS
6
9-89

AN833-6D Purchased No 110 Each 14.0000

AN833-6D

Elbow, Bulkhead-M-Flare

DAS
27
9-89

Location Loc Qty Loc Code

CCK006 11
M130466 11
ST324 3
M130466 3

**

DAS
6
9-89

AN924-6D Purchased No 110 Each 49.0000

AN924-6D

Nut

DAS
27
9-89

Location Loc Qty Loc Code

ST322 49
m132680 10
m133938 15
m134502 24

**

DAS
6
9-89

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Work Order ID: 143880

143880

Parent Item: D205-706-013

D205-706-013

Parent Item Name: Fuel Purge Canister

Start Date: 4/1/2016

Required Date: 4/8/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0332J

Purchased

No

110

Each

1,822.000

4

48

NAS1149D0332.J

Washer

**

DAS
6
9-89

Location

Loc Qty

Loc Code

CA

10

m129682

10

GA

110

m132677

110

ST260a

1600

m133988

600

m134502

1000

ST266

102

m133498

102

NAS1149D0363J

Purchased

No

110

Each

1,631.000

8

8/10

NAS1149D0363.J

Washer

**

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

633

m134055

633

Return2016

2

m132317

2

ST263

996

m134370

996

NAS1149D0963J

Purchased

No

110

Each

70.0000

2

24

NAS1149D0963.J

Washer

**

DAS
6
9-89

Location

Loc Qty

Loc Code

ST263

70

125445

70

DAS
27
9-89

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Work Order ID: 143880

143880

Parent Item: D205-706-013

D205-706-013

Parent Item Name: Fuel Purge Canister

Start Date: 4/1/2016

Required Date: 4/8/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

110

Each

2,371.000

MS21042L3

Nut

**

DAS
6
9-89

Location

Loc Qty

Loc Code

FP001

100

m133790

100

GA

828

m133790

28

m134360

800

OVER007

1200

m134360

1200

Return2016

1

M132382

1

ST304

242

m134039

242

MS21919-WDG12

Purchased

No

110

Each

37.0000

MS21919-WDG12

Clamp

**

DAS
6
9-89

Location

Loc Qty

Loc Code

ST293

37

m129630

37

MS21919-WDG16

Purchased

No

110

Each

10.0000

MS21919-WDG16

Clamp

**

DAS
6
9-89

Location

Loc Qty

Loc Code

ST292

10

m128635

2

m133363

8

DAS
27
9-89

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Work Order ID: 143880

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Parent Item: D205-706-013

D205-706-013

Parent Item Name: Fuel Purge Canister

Start Date: 4/1/2016

Required Date: 4/8/2016

Start Qty: 1.00

Required Qty: 1.00

MS21919-WDG9

Purchased

No

110

Each

200.0000

5

510

MS21919-WDG9

Clamp

Location

Loc Qty

Loc Code

CCK006

100

m134544

100

ST293

100

m134376

100

MS21920-42

Purchased

No

110

Each

10.0000

2

24

MS21920-42

CLAMP

Location

Loc Qty

Loc Code

ST546

10

m132550

4

m134050

6

MS29512-06

Purchased

No

110

Each

31.0000

5

510

MS29512-06

O-RING

Location

Loc Qty

Loc Code

ST274

31

m132617

15

m132680

16

MS35489-11

Purchased

No

110

Each

17.0000

17

12

MS35489-11

GROMMET

Location

Loc Qty

Loc Code

ST269

17

m129499

17

DAS
27
9-89

APR 14 2016

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REFERENCE ONLY

5. PARTS LIST

Qty -011	Qty -013	Qty -015	Part Number	Description
X			D412-706-011	FUEL PURGE CANISTER INSTALLATION (212/412)
	X		D205-706-013	FUEL PURGE CANISTER INSTALLATION (205/214/EAGLE SINGLE)
		X	D204-706-015	FUEL PURGE CANISTER INSTALLATION (204)
1	1	1	D2001-4	VALVE ASSEMBLY
		2	D2026-101	SCREW
	1	1	D3262-041	CANISTER ASSEMBLY
1			D3262-043	CANISTER ASSEMBLY
2	2	2	D3264-1	BRACKET
1			D3297-1-0098	HOSE ASSEMBLY
1	1		D3297-1-0121	HOSE ASSEMBLY
	1		D3297-1-0130	HOSE ASSEMBLY
1			D3297-3-0210	HOSE ASSEMBLY
	1		D3297-3-0350	HOSE ASSEMBLY
		1	D3297-5-0410	HOSE ASSEMBLY
	1		D3298-001	TUBE ASSEMBLY
1			D3298-005	TUBE ASSEMBLY
1			D3298-007	TUBE ASSEMBLY
	1		D3298-009	TUBE ASSEMBLY
		1	D3298-011	TUBE ASSEMBLY
		1	D3298-013	TUBE ASSEMBLY
		1	D3298-015	TUBE ASSEMBLY
	1	1	D3299-1	FITTING
1	1		D3299-3	FITTING
1			D3299-5	FITTING
1			D3299-7	FITTING
1	1	1	D3301-1	PLACARD
1	1	1	D3301-3	PLACARD
1	1		D3302-1	DOUBLER
1	1		D3302-3	DOUBLER
		1	D3302-5	DOUBLER
		2	D3302-7	DOUBLER
2			D3329-1	BUSHING
1			D4054-001	TUBE ASSEMBLY
1			D4054-003	TUBE ASSEMBLY
1			D4054-009	TUBE ASSEMBLY
4	4	4	AN3-5A 1	BOLT
	1	1	AN814-6D	PLUG
1			AN814-8D	PLUG
2	2	2	AN815-6D	UNION
1			AN815-8D	UNION
		1	AN816-6D	NIPPLE
2	3	1	AN833-6D	ELBOW

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Revision: B
 Date: 12.11.06

Qty -011	Qty -013	Qty -015	Part Number	Description
1			AN833-8D	ELBOW
		1	AN919-6D	REDUCER
4	4	1	AN924-6D	NUT
1			AN924-8D	NUT
1			AN938-6D	TEE
4	4	2	AN960JD10L	WASHER
8	8	8	AN960JD10	WASHER
2	2		AN960JD916	WASHER
4	4	4	MS21042L3	NUT
	1	1	MS21919WDG12	CLAMP
	2		MS21919WDG16	CLAMP
		2	MS21919WDG6	CLAMP
		3	MS21919WDG7	CLAMP
2	5		MS21919WDG9	CLAMP
2	2	2	MS21920-42	CLAMP
7	5	5	MS29512-06	O-RING (OR M83248/1-906)
3			MS29512-08	O-RING (OR M83248/1-908)
	1	1	MS35489-11	GROMMET
1			MS35489-16	GROMMET

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Revision: **B**
Date: 12.11.06